

Work Order ID 69134

Page 1

Tuesday, May 03, 2011 10:52:11 AM

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 5/3/2011 Start Qty: 1.00



Required Date: 5/9/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4030

C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69134

Page 2

Tuesday, May 03, 2011 10:52:11 AM

Item ID: D4030-041 Accept

Revision ID:

Item Name: Long Basket Assembly (350)

Start Date: 5/3/2011 Start Qty: 1.00

Required Date: 5/9/2011 Req'd Qty: 1.00

Reference:



Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PMP69/44

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

PMP69/44

5/5/18

H11-05-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 03, 2011 10:52:18 AM

Page 1

Work Order ID: 69134

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)






Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	13.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST506		13							
				66563		7							
				68363		6							
D2535  Spring		Manufactured	No			100	Each	51.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		51							
				66764		51							
D2537  Bushing		Manufactured	No			100	Each	44.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		44							
				65077		2							
				66972		42							
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			
D3914-041  Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1	1			

SP

1

2

2

2

2

69138

69141

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tuesday, May 03, 2011 10:52:18 AM

Page 2

Work Order ID: 69134

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3917-3
Washer

Manufactured No

100 Each 18.0000

6 6
SP

Location

Loc Qty

Loc Code

ST091

18

67780

18

D3953-3
Gas Spring Stud, Lid

Manufactured No

100 Each 9.0000

2 2
SP

Location

Loc Qty

Loc Code

ST096

9

68230

9

D3953-7
Spring Spacer

Manufactured No

100 Each 26.0000

2 2
SP

Location

Loc Qty

Loc Code

ST096

26

65053

4

68464

22

D3953-9
Gas Spring Washer

Manufactured No

100 Each 8.0000

2 2
SP

Location

Loc Qty

Loc Code

ST096

8

68231

8

D3953-17
Gas Spring Spacer

Manufactured No

100 Each 15.0000

2 2
SP 11/5/10

Location

Loc Qty

Loc Code

ST096

15

67968

15

Tuesday, May 03, 2011 10:52:18 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, May 03, 2011 10:52:18 AM

Page 3

Work Order ID: 69134

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-19

 Gas Spring Bracket

Manufactured No

100 Each 23.0000 1



1

Location

Loc Qty

Loc Code

ST096

23

59213

1

64810

2

68462

20

D3953-21

 Gas Spring Bracket

Manufactured No

100 Each 22.0000 1



1

Location

Loc Qty

Loc Code

ST096

22

66110

2

68463

20

D3969-3

 Spring (Basket Lid)

Manufactured No

100 Each 23.0000 1



1

Location

Loc Qty

Loc Code

ST272

23

64285

1

68653

2

68925

20

AN3-14A

 Bolt

Purchased No

100 Each 33.0000 4



4
11/5/10

Location

Loc Qty

Loc Code

ST351

33

117513

33

4

Tuesday, May 03, 2011 10:52:19 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Tuesday, May 03, 2011 10:52:19 AM

Page 4

Work Order ID: 69134

Parent Item: D4030-041




Parent Item Name: Long Basket Assembly (350)

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-16A	Purchased	No	100	Each	161.0000	2		
								
Bolt								

Tuesday, May 03, 2011 10:52:19 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tuesday, May 03, 2011 10:52:19 AM

Page 5

Work Order ID: 69134

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/3/2011

Required Date: 5/9/2011


Start Qty: 1.00

Required Qty: 1.00

AN310C4

 Nut

Purchased No

100 Each 68.0000 2
 *SP*

Location

Loc Qty

Loc Code

ST324

68

116741

18

117395


50

a

MS21042L3

 Nut

Purchased No

100 Each 2,079.000 6
 *SP*

Location

Loc Qty

Loc Code

ST300

2079

116391

11

116540

502

116549

766

117441


800

b

MS21042L5

 Nut

Purchased No

100 Each 1,263.000 4
 *SP*

Location

Loc Qty

Loc Code

ST300

1263

116105

403

116548

260

117441

500

117591


100

4

MS24665-151

 Cotter Pin

Purchased No

100 Each 495.0000 3
 *11/5/10 SP*

Location

Loc Qty

Loc Code

ST309

495

17566

495

2

Tuesday, May 03, 2011 10:52:19 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 69134

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

86.0000

2



Cotter Pin

Location

Loc Qty

Loc Code

ST309

86

116823

86

100

Each

656.0000

6

NAS1149F0432P

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST275

656

117291

656

100

Each

60.0000

4

NAS1149F0563P

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST275

60

114576

60

100

Each

124.0000

8

NAS1149F0332P

Purchased

No



WASHER

Location

Loc Qty

Loc Code

ST275

124

17317

124

100

Each

6,372.000

2

NAS1149C0432R

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST297

6372

116900

1372

117291

5000

Tuesday, May 03, 2011 10:52:20 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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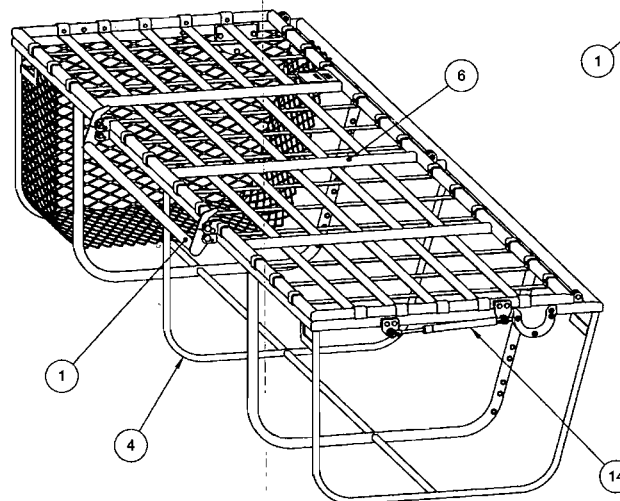
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	1	D3914-041	LONG BASKET LID ASSY (350)
6	1	1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2	2	AN3-16A	BOLT
17	2	2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	4	AN5-17A	BOLT
20	2	2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L6	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER

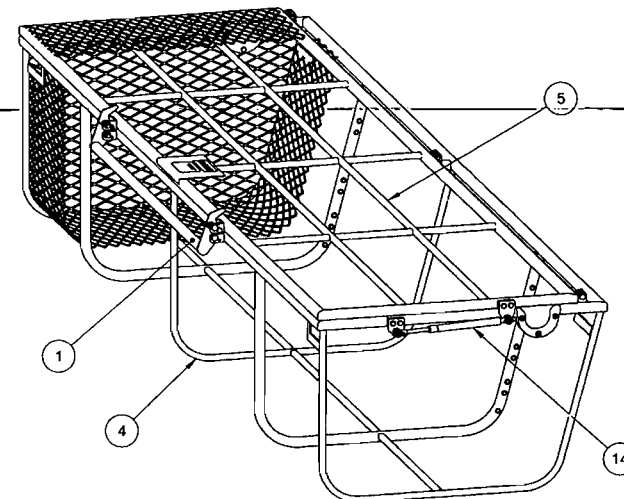
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 69139

PL11-05-3



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

RELEASED
10.08.12
ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3)	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D4030	SHEET 1 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	LONG BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

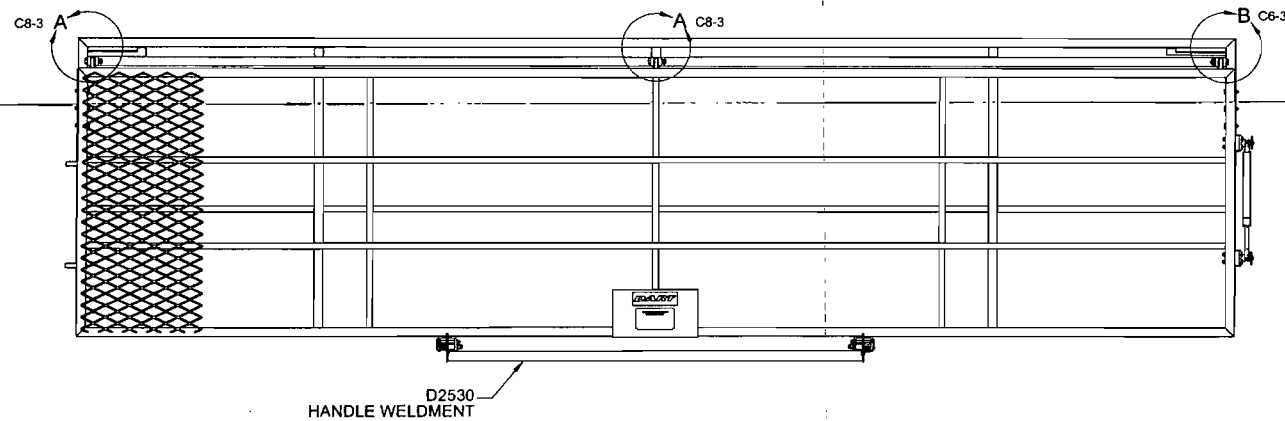
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

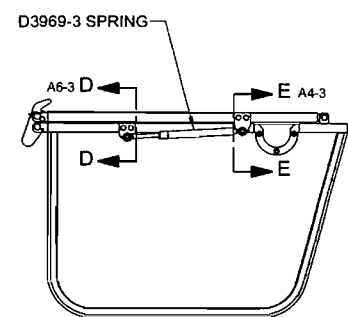
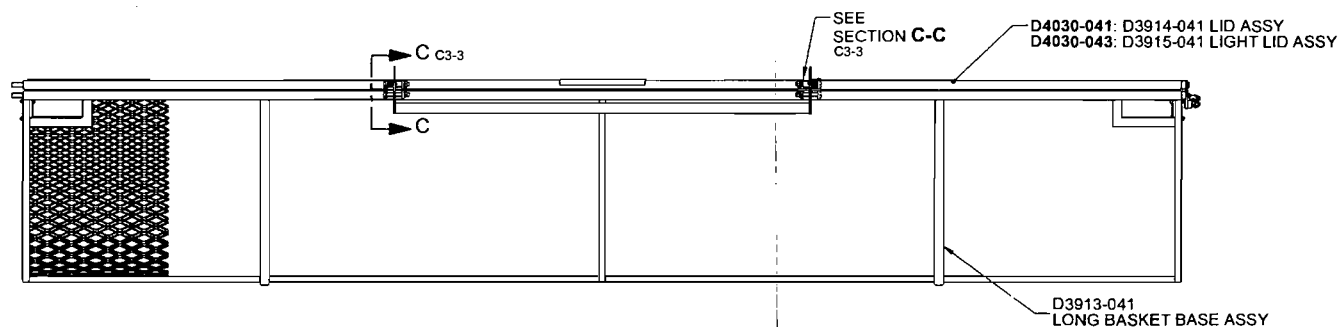
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



u/c 09134



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SE	DRAWING NO.	REV. C
MFG. APPR.	SE	D4030	SHEET 2 OF 3
APPROVED	SE	TITLE	SCALE
DE APPR.	SE	LONG BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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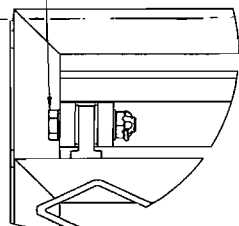
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

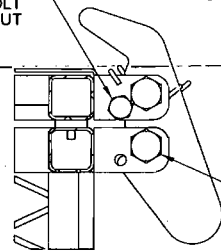
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL A D8-2
D5-2

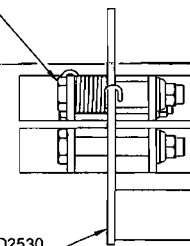
D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

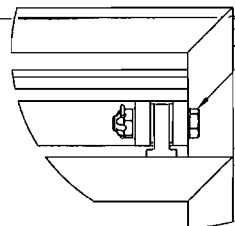
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530
HANDLE WELDMENT
REF

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D3-2

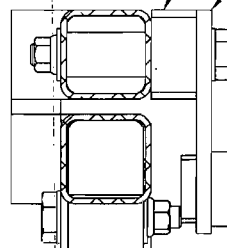
D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL



SECTION E-E B1-2

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

u1069134

RELEASED
10.08.12

DESIGN	4.5	DART AEROSPACE LTD	
DRAWN	4	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED	4	TITLE	SCALE
DE APPR.	4	LONG BASKET-ASSY (350) NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries